

33

Date: Thursday, 7/19/2007 2:30:06 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206L AFT X-TUBE
Job Number : 33689	
Estimate Number : 10973	
P.O. Number : N/A	Part Number : D206667203
This Issue : 7/19/2007 S.O. No. : N/A	Drawing Number : D206-667-243 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LANDING GEAR	Drawing Revision : B
Previous Run : 33688	Material : N/A
Written By : <u>JA 07.07.19</u>	Due Date : 8/12/2007 Qty: 1 Um: Each
Checked & Approved By : <u>JA 07.07.19</u>	
Comment : Est Rev. 05.09.01 Add holes for compatibility with Bell Skid tubes KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-203 CHG002

Ref. Amended

2.0	D6004115	Crosstube material
-----	----------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6004-115 Crosstube 2014

Check OD = 2.500"; ID = 1.800"

36 07.07.26

①

3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
-----	------------	----------------------------



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA089

2-Turn first side as per Folio FA089

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243.

36 07.07.26

①

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
-----	-----	------------------------------



Comment: INSPECT ALL DIM TO DIM SHEET

36 07.07.26

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 206L AFT X-TUBE

Job Number: 33689

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA089

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243.

3-Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-243

Inside of Cuff(Donot engrave on outside of tube)

BG 07-07-26

(1)

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

BG 07-07-26

(1)

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 07/04/27

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

Jb 7-7-27

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ed 07/07/27 (1)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Jb 7-7-30

11.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-243 using CNC bender program 206L-AF and Folio FT

DP 7-8-10

W/O:		WORK ORDER CHANGES					
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Drawing Name: 206L AFT X-TUBE

Job Number: 33689

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

En 07/08/13

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill all (3) top holes.

2-Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243
Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243

6-Drill Fwd rivet holes using drill Jig DT8789FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8789 as per Dwg D206-667-243.

8-C'sink holes as per Dwg D206-667-243.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243

En 7-8-13

JD 7-8-14

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

En 07-08-14

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

En 07-08-14

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/08/14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: 206L AFT X-TUBE

Job Number: 33689

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

OUTSIDE SERV.10

OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 0380r

Issue P/O: 4353

LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

0207/08/14

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

2/8/15 SP

19.0

QC6

DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

07/08/15 (76)

20.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045

Nut Plate

32164

27 07 08 -16

21.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043

Nut Plate

32802

27 07 08 -16

22.0

MS20601AD4W10

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W10 Rivet

104093

27 07 08 -16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 33689

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install nut plates as per Dwg D206-667-243.

RT 07-08-16

24.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Mask Threaded holes

2-Prime inside and outside crosstube as per QSI 005 4.2

3-Paint outside crosstube with White Imron as per QSI 005 4.2

ml 070815 1

25.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

RT 07-08-16

26.0

D2856400

Abrasion Strip



Comment: Qty.: 1.3525 f(s)/Unit Total : 1.3525 f(s)

Pick:

Qty Part number Description Batch

2 D2856-400(Cut to 7.73") Abrasion Strip

32020

RT 07-08-16

27.0

D28921

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2892-1 Support

28389

RT 07-08-16

28.0

MS2192022

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-22

Clamp

102389

RT 07-08-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: 206L AFT X-TUBE

Job Number: 33689

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description:

29.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8580. Note: (3) top holes should be facing up.

2-Install supports and clamps as per Dwg D206-667-243. Torque clamps to 80-100 in lb

} 8T 02-0816

30.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/08/16 (L)

31.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

32.0

AN534A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: M102850

SP

33.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

Batch: M104118

SP

34.0

AN510A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

10 AN5-10A

Bolt M102404

5 M10493L SP

35.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

M104885

7/8/16 SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Drawing Name: 206L AFT X-TUBE

Job Number: 33689

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

4 AN5-32A

Bolt M104885

36.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick: Packing Kit

Qty Part number

Description Batch

18 AN960JD516

Washer

M104156

7/8/16 SP

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

ED 07/18/16

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-203

Location: _____

PPP Rev: _____

Rec C 7/8/16 SP EP

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07-08-17

Job Completion



07-08-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 33689
Description: Crosstube Assembly	Part Number: D206-667-243
Inspection Dwg: D206-667-243 Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

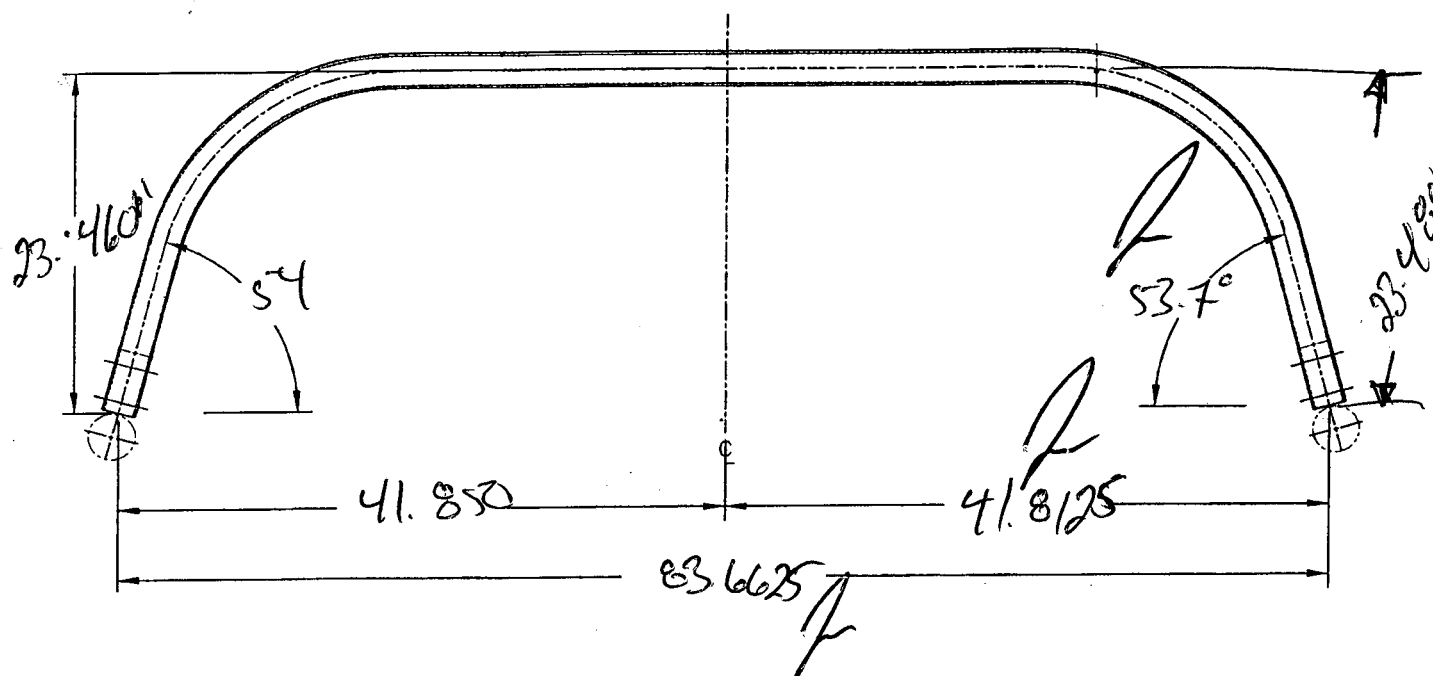
Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.490	+0.005/-0.000	2.492	✓			
	2.018	+0.005/-0.000	2.021				
	2.079	+0.005/-0.000	2.084				
	2.145	+0.005/-0.000	2.150				
	2.209	+0.005/-0.000	2.214				
	2.287	+0.005/-0.000	2.292				
	2.363	+0.005/-0.000	2.368				
	2.433	+0.005/-0.000	2.438				
	0.200	+/-0.010	.200				
	0.500 x 30°	+/-0.010	.500				
	R0.063	+/-0.010	.063				
	R0.500	+/-0.010	.500				
	4.438	+/-0.030	4.438				
SIDE B	104.91	+/-0.020	104.91				
	2.490	+0.005/-0.000	2.492				
	2.018	+0.005/-0.000	2.020				
	2.079	+0.005/-0.000	2.082				
	2.145	+0.005/-0.000	2.149				
	2.209	+0.005/-0.000	2.214				
	2.287	+0.005/-0.000	2.292				
	2.363	+0.005/-0.000	2.368				
	2.433	+0.005/-0.000	2.438				
	0.200	+/-0.010	.200				
	0.500 x 30°	+/-0.010	.500				
	R0.063	+/-0.010	.063				
	R0.500	+/-0.010	.500				
	4.438	+/-0.030	4.438				

Measured by: SG	Audited by: J.L	Prototype Approval:	N/A
Date: 07.07.26	Date: 07/07/27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.01	New Issue (P/O D206-667-203)	KJ/JLM	

DART AEROSPACE LTD		Work Order:	33689
Description: Crosstube High Aft (206L)		Part Number:	D206-667-203
Inspection Dwg: D206-667-243 Rev: B		Page 1 of 1	

Required Dimension	Min	Max
Height	23.46	23.58
1/2 Span	41.86	41.98
Angle	54	56
Total Span	83.72	83.96



Comments

QC15 Inspection	<i>R/Er</i>
Date	07/02/13

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM <i>af</i>	<i>[Signature]</i>



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED # DS	APPROVED # DS	DRAWING NO. D206-667-243	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206L HIGH AFT) NTS	
A	00.11.17	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05.07.26 #

UNDER REVIEW

06.07.10 RH

12 draw detail F

RH

07.05.02

Qty	Part Number	Description
X	D206-667-243	CROSSTUBE ASSEMBLY
1	D6004-115	CROSSTUBE
2	D2856-400-773	ABRASION STRIP
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2892-1	SUPPORT
14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
4	MS21920-22	CLAMP

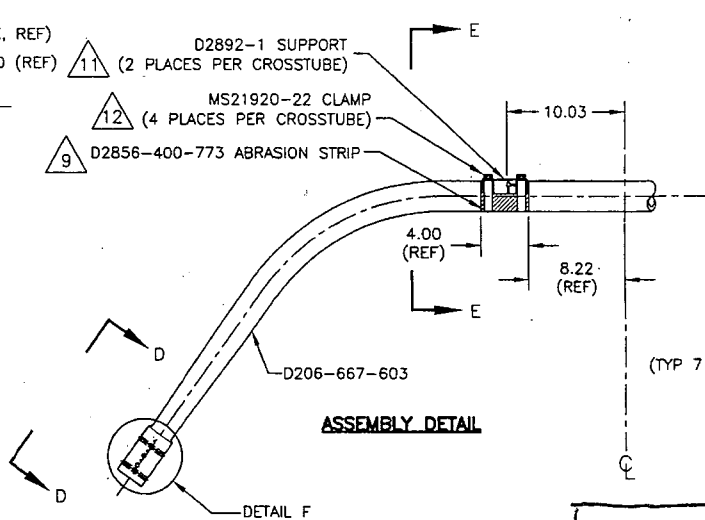
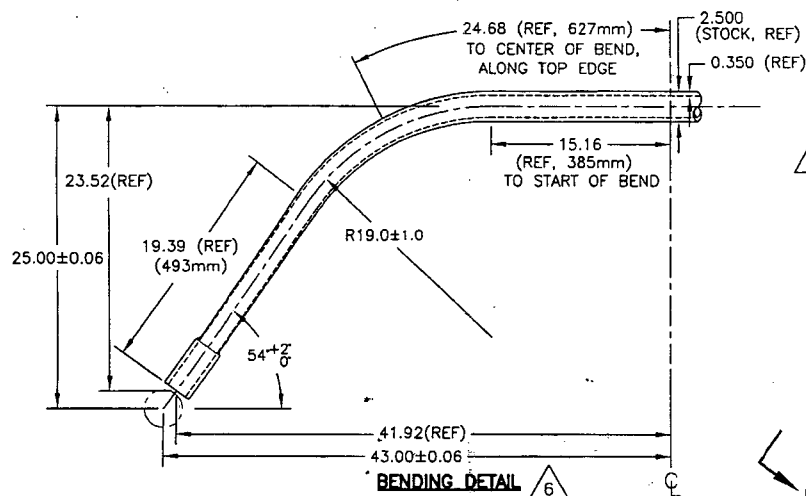
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6004-115
FINISHED LENGTH = 104.91±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-773 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2892-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33689

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B $\varnothing 0.323^{+0.005}_{-0.000}$
(TYP 5 PLACES PER CUFF)
HOLE TO BE ALIGNED WITHIN ± 0.001
OF HOLE ON OTHER SIDE OF CUFF

PILOT $\varnothing 0.128$
C'SINK $\varnothing 0.225 \times 100'$
(TYP 7 PLACES PER CUFF)

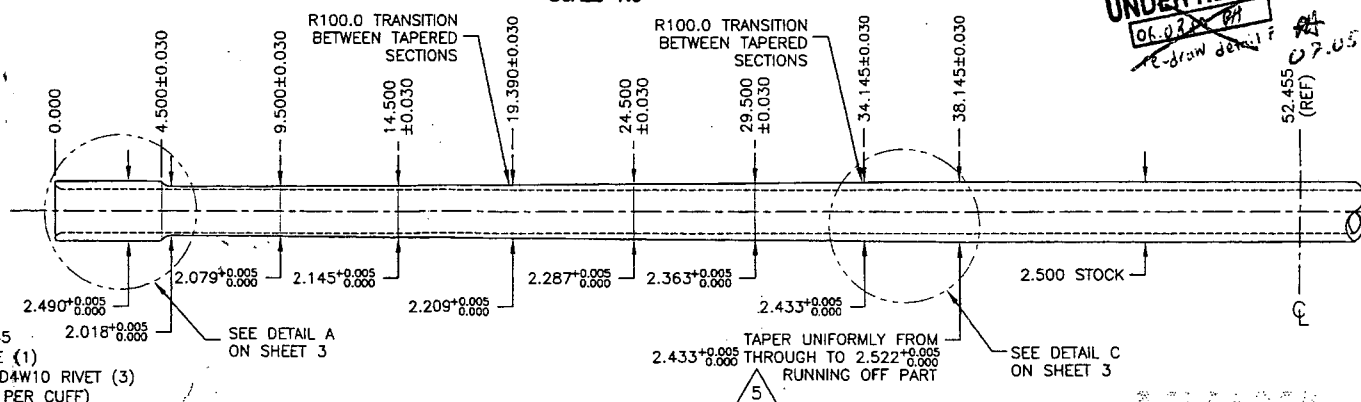
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DETAIL F
SCALE 2:5

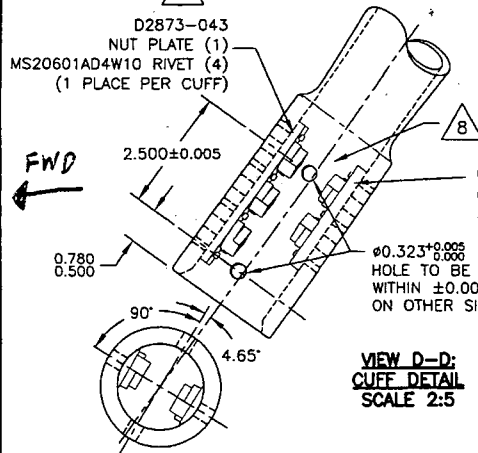
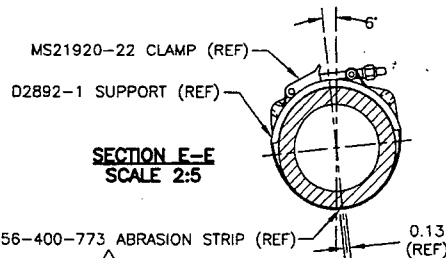
UNDER REVIEW
06.03.26 BA
re-draw detail F

FWD SIDE ONLY

TURNING DETAIL
SCALE 1:5



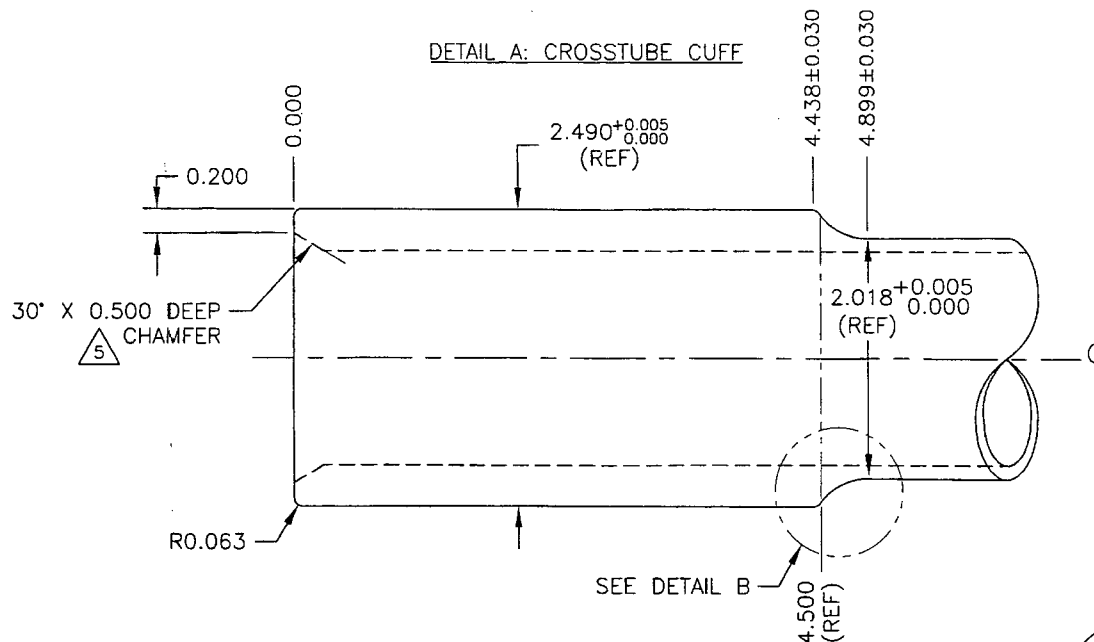
SECTION E-E
SCALE 2:5



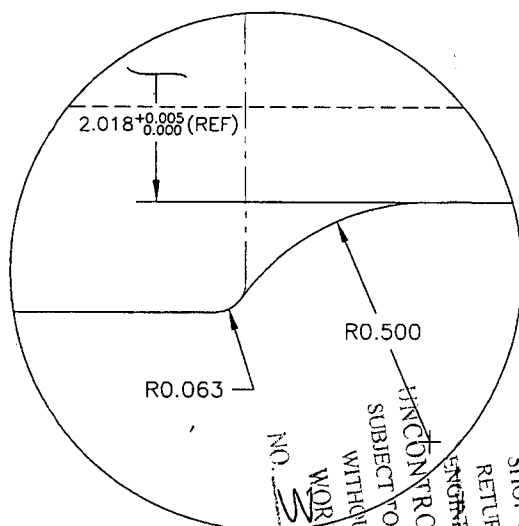
NO. 33689
WORK ORDER
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

COPYRIGHT © 2000 BY DART AEROSPACE LTD.		DESIGN PH	DRAWN BY PH	DART	DART AEROSPACE LTD. HAYESBURY, ONTARIO, CANADA
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED DS	APPROVED DS	DRAWING NO. D206-667-243	REV. B SHEET 2 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206L HIGH AFT)		SCALE 1:10	

DETAIL A: CROSSTUBE CUFF

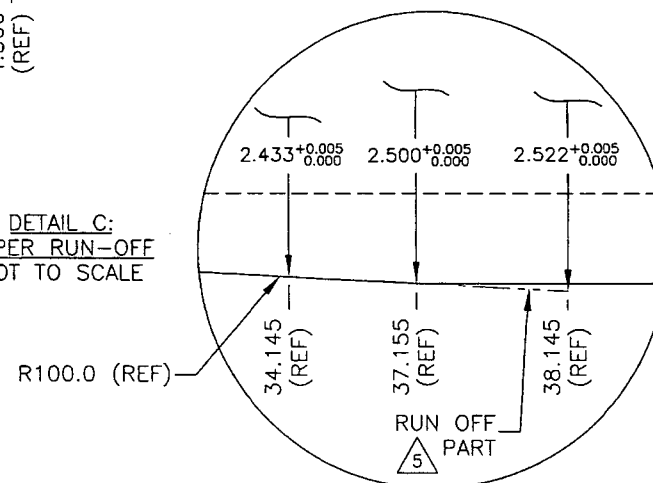


05.07.26 PH
 UNDER REVIEW
 OG.03.06 PH
 Re-drawn detail F
 PH 07.05.02



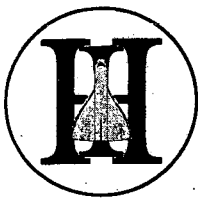
DETAIL B: CUFF
 TRANSITION
 SCALE 4:1

DETAIL C:
 TAPER RUN-OFF
 NOT TO SCALE



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DATE 05.07.26		DRAWING NO. D206-667-243		TITLE CROSSTUBE ASS'Y (206L HIGH AFT)	SCALE 1:



HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 37152

A.M.O. Number: 46/90

NON-DESTRUCTIVE TESTING REPORT

AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

INSPECTION REQUIREMENTS

Carry out FPI of four (4) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI-038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty. (1) P/N D206-667-203 S/N B33689

Qty. (1) P/N D206-667-203BL S/N B33160

Qty. (1) P/N D206-667-103BL S/N B33154

Qty. (1) P/N D206-667-103 S/N B33686

☐ RADIOGRAPHY

☐ ULTRASONIC

☒ PENETRANT

☐ MAGNETIC PARTICLE

☐ EDDY CURRENT

INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on four (4) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)
Ardrox 970P25E Batch #04B503.

Four (4) cross tubes PASSED inspection.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY:

S. FLETCHER

DATE August 14, 2007

INSPECTION
STAMP(S) Not Required

CUSTOMER INFORMATION

CUSTOMER Dart Aerospace

P.O. NUMBER

4353

ADDRESS:

CONTACT NAME:

LABOUR

@

\$

MATERIALS

@

TRAVEL EXPENSES

@

GST

HOTEL EXPENSES

@

PST

INVOICE NO.

TOTAL \$